

Work Order ID 70300

Thursday, June 02, 2011 1:51:48 PM



Page 1

Item ID: D3183-044

Accept



Setup Start



Revision ID:

Item Name: Bracket Assembly

Stop



Start Date: 6/8/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/24/2011 Req'd Qty: 4.00



Customer:

Reference: J.D. 11/06/06

Approvals: Process Plan:

Date: Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3183	Rev C1

100



BAND SAW

0.00

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: (1.500" x 2.250") 5.500" long

110



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

1-Machine D3183-4 as per Folio FA322 and Dwg D3183-1 Identify as D3183-4
2-Deburr 3-Scribe batch number

D.A 11/08/17

4 Ø

120



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

D.A 11/08/31

4 Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

6/8/03

0.00

4 0

140



Small Fab

Small Fab

0.00

6/8/03 (4)

Small Fab

Memo

0.00

Assemble D3183-043 as per Dwg D3183.

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

6/8/03
al09/06

Memo

0.00

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Setup Start



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Item Name: Bracket Assembly

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Start Date: 6/8/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/24/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date: _____

Tooling:

Date: _____

Run Start



QC:

Date: _____

SPC (Y/N):

Date: _____

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location: ST2310 A 0.00



Packaging

Memo

0.00

SP 11-09-06

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

n/a 6/06

MF

11-09-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, June 02, 2011 1:51:45 PM

Page 1

Work Order ID: 70300



Parent Item: D3183-044



Parent Item Name: Bracket Assembly

Start Date: 6/8/2011

Required Date: 6/24/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:Pick:A|04.02.18|New issue :KJ/DS;
IPP Rev:B Changed Mat Size 08-06-26 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3121-21		Manufactured	No			140	Each	35.0000	2	8		<i>E/J 11/09/06</i>	
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Bolt

Location	Loc Qty	Loc Code
ST235	35	
66969	3	
68955	32	

D3183-045		Manufactured	No			100	Each	25.0000	2	8		<i>E/J 11/09/06</i>	
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Bearing Assembly

Location	Loc Qty	Loc Code
ST236	25	
68256	18	
68629	7	

M174B1.500X02.250		Purchased	No			140	f	30.9603	0.4583	1.929684		<i>E/J 11/09/06</i>	
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17-4 SS Bar 1.50 X2.250

Location	Loc Qty	Loc Code
MAT031	30.9603	
108309	1.08	
113568	11.8333	
115806	18.047	

1.929684 E/J 11/09/06

OK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

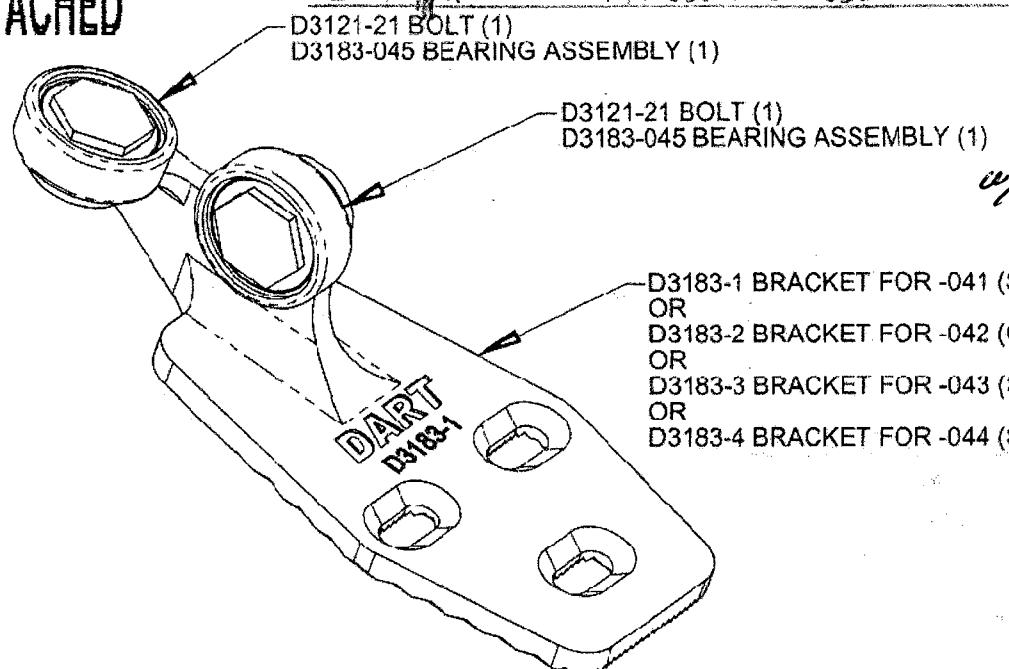


6 COPY ISSUED

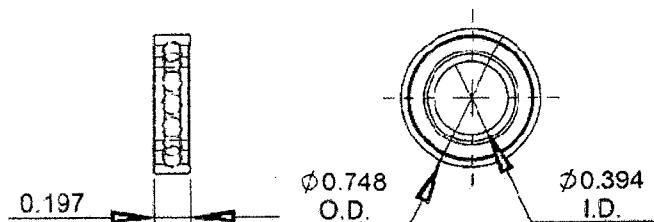
DESIGN #	DRAWN BY IP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3183	REV. C SHEET 1 OF 4
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1
A. 03.01.24		NEW ISSUE	
B. 03.06.17		REMOVE BEARING; 1.012 WS 0.882	
C. 04.02.17		ADD -045-9; 0.182 WAS 0.431	
C1. 04.11.09		0.830 WAS 0.850	

RELEASED
04.03.01 C/P

DEO ATTACHED

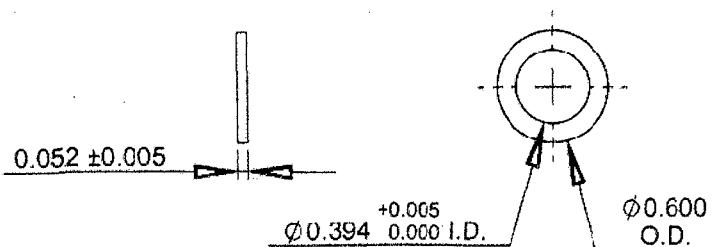


D3183-041 BRACKET ASSEMBLY (SHOWN)
D3183-042 BRACKET ASSEMBLY (OPPOSITE)
D3183-043 BRACKET ASSEMBLY (SIMILAR)
D3183-044 BRACKET ASSEMBLY (SIMILAR)



D3183-5 BEARING: SPECIFICATION CONTROL DRAWING

- 1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
- 2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
- 3) ALL DIMENSIONS ARE IN INCHES



D3183-7 WASHER

- 1) MATERIAL: AISI 303 ROUND BAR (M303R) ANNEALED
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE LTD	Work Order:	70300
Description: Bracket	Part Number:	D3183-4
Inspection Dwg: D3183 Rev: C1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.190	+/-0.030	R0.188	✓		R-G	ref.
R0.063	+/-0.010	R0.063	✓		"	"
0.182	+/-0.010	0.186	✓		Vern	GA-01
0.070	+/-0.010	0.069	✓		H-G	31006
0.100	+/-0.010	0.099	✓		Vern	GA-01
Ø0.201 x 0.100	+/-0.010	Ø0.200x.099	✓		"	"
0.182	+/-0.010	0.183	✓		"	"
5.32	+/-0.030	5.325	✓		H-G	31006
5.036	+/-0.010	5.038	✓		"	"
2.120	+/-0.010	2.121	✓		"	"
1.290	+/-0.010	1.291	✓		"	"
0.365	+/-0.010	0.365	✓		"	"
0.218	+/-0.010	0.214	✓		Vern	GA-01
1.030	+/-0.010	1.031	✓		"	"
1.90	+/-0.030	1.886	✓		"	"
1.012	+/-0.010	1.013	✓		H-G	31006
Ø0.201 x 0.100	+/-0.010	Ø0.201x.099	✓		Vern	GA-01
0.786	+/-0.010	0.777	✓		H-G	31006
Ø0.392	+0.002/-0.000	Ø0.3923	✓		MIC	GA-03
R0.19	+/-0.030	R0.188	✓		R-G	ref.
3.954	+/-0.010	3.958	✓		H-G	31006
0.162	+/-0.010	0.164	✓		Vern	GA-01
R0.19	+/-0.030	R0.188	✓		R-G	ref.
R0.25	+/-0.030	R0.250	✓		"	"
4.26	+/-0.030	4.260	✓		"	"
2.800 Calculated dimension	+/-0.030	2.820	✓		Vern	GA-01
0.162	+/-0.010	0.162	✓		"	"
0.615	+/-0.010	0.606	✓		"	"
0.435	+/-0.010	0.431	✓		"	"
0.200	+/-0.010	0.200	✓		"	"
0.381	+/-0.010	0.373	✓		"	"
0.032	+/-0.010	0.032	✓		D-G	GA-08

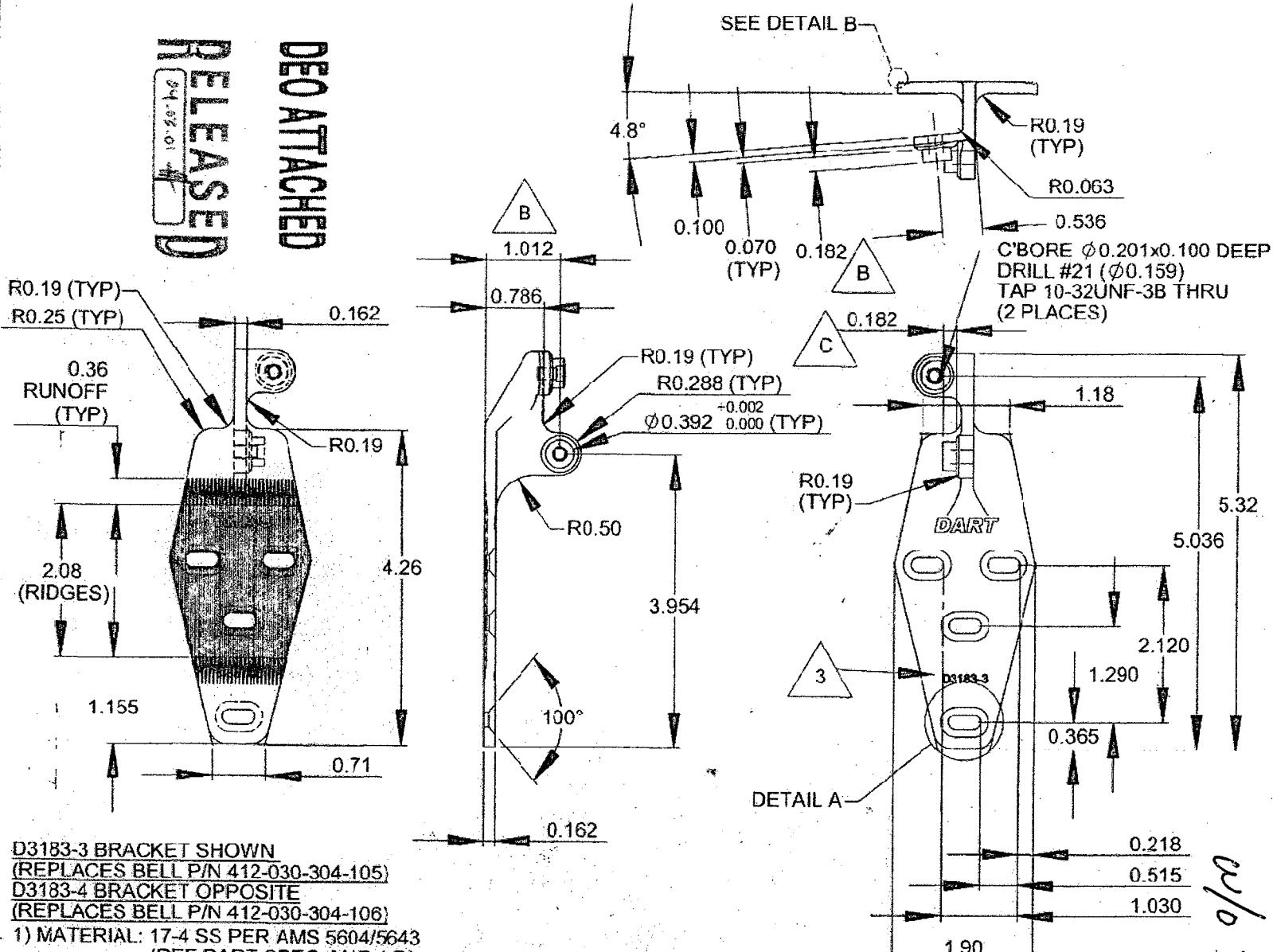
Measured by:	B.A	Audited by:	✓	Preliminary Approval:	N/A
Date:	11/09/03	Date:	11/09/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.12	New Issue P/O D3183-044	KJ/RF	
B	04.03.15	Changes as per revision C	KJ/JLM/RF	
C	04.06.15	Dimension 2.800 was 2.080; removed 1.155, 0.36 dimensions	KJ/JLM	
D	06.03.09	Dwg Rev update	KJ/JLM	
E	08.01.16	Dimensions revised	KJ/EC/DD	
F	10.09.23	Dimensions revised	KJ	✓

DART

CACOPY IS
OCT 2003

DESIGN	DRAWN BY	<i>[Signature]</i>	DART AEROSPACE LTD
			HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	<i>[Signature]</i>	DRAWING NO.
			D3183
DATE	TITLE	04.02.17	BRACKET ASSEMBLY
			W/ b 7030
			REV. C
			SHEET 3 OF 4
	SCALE	1:2	



- 1) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) ENGRAVE DART P/N & LOGO AS SHOWN
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES